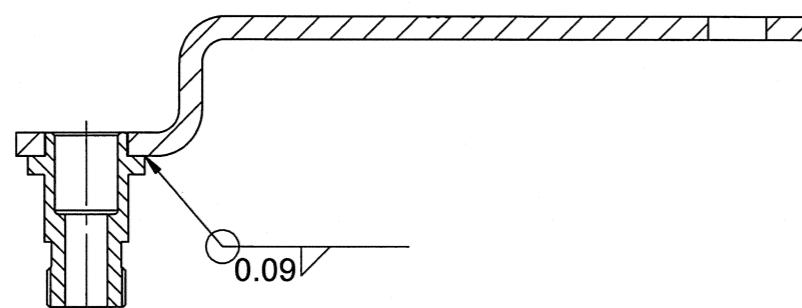
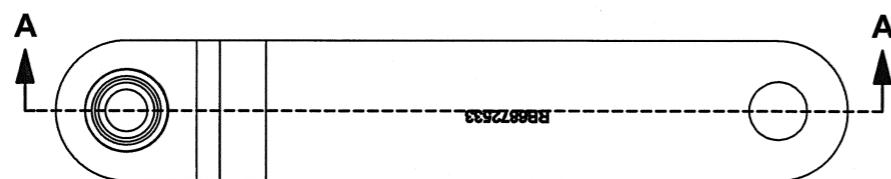
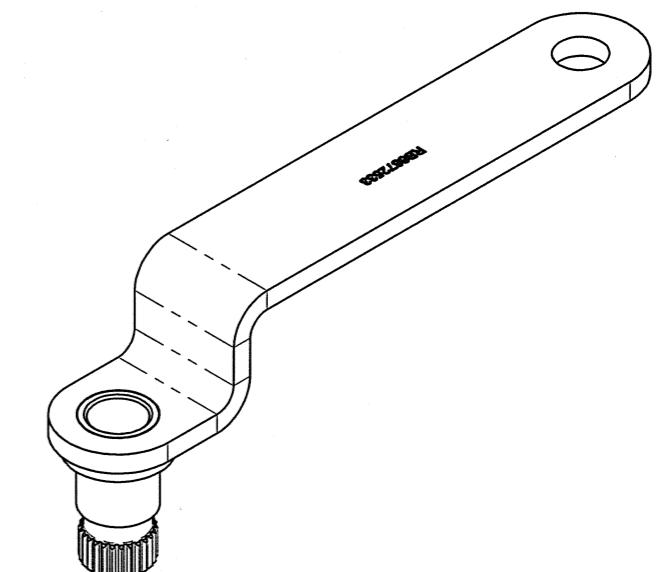
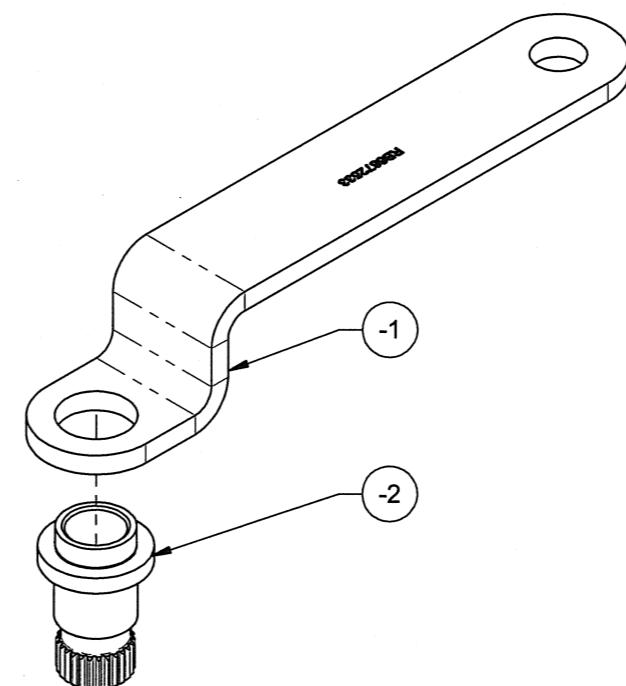


ITEM #	QTY	PART #	PART TITLE
-1	1	RB6872533-1	HANDLE
-2	1	RB6872533-2	WRENCH

D D
C C
B B
A A



SECTION A-A



RB6872533 WRENCH AND HOLDER INST/REM COMPRESSOR TIE BOLT

9

NOTES:

1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) IDENTIFICATION: N/A

7) ASSEMBLE AS SHOWN

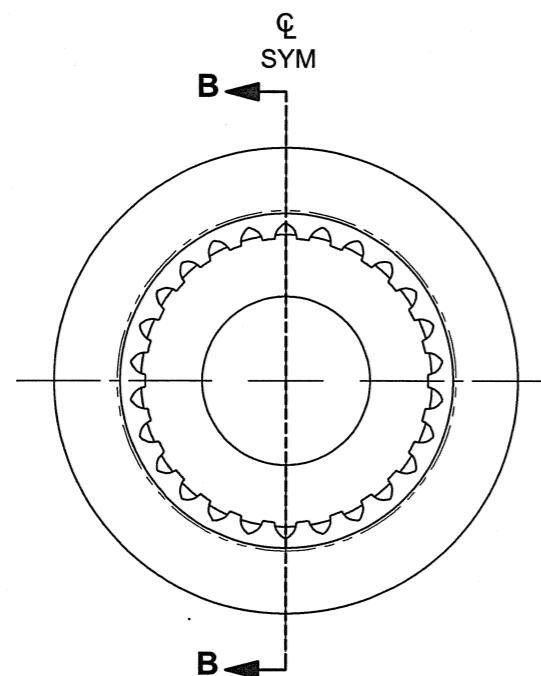
8) REMOVE ALL WELD SPATTERS

9) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

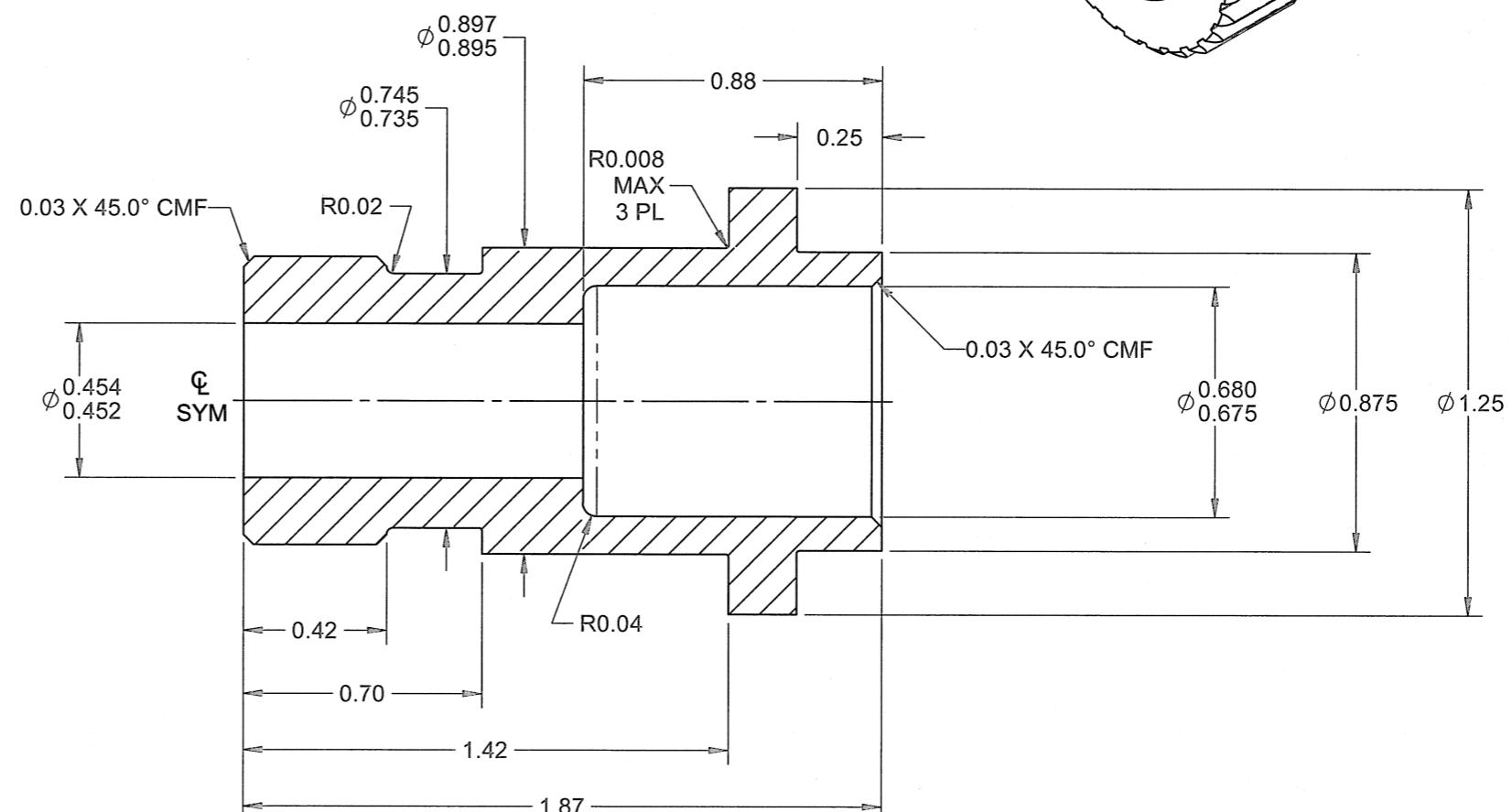
B	HEAT TREAT ON PAGE 1 REMOVED ITEM -2 HEAT TREAT 48-52 Rc ADDED ITEM -1 MATERIAL 4140 CHANGED FOR 4140 (28-32 Rc)	19-813	VM
A	NEW ISSUE		VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	TOOL PART #	REV. B
MFG. APPR.	JFC	RB6872533	SHEET 1 OF 3
APPROVED	<i>Vip</i>	TITLE	SCALE
DATE	2019-07-10	WRENCH AND HOLDER INST/REM COMPRESSOR TIE BOLT	NTS
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SPLINE INFO:

32/64 PITCH 26 TEETH
PRESSURE ANGLE : 30.0°
ARC TOOTH THICKNESS : 0.0441" +0/-0.002"
ROOT DIA : 0.762"
PITCH DIA : 0.8125"
OUTSIDE DIA : 0.844 +0/-0.005"
BASE CIRCLE DIA : 0.7036
DIMENSION OVER TWO 0.0540" DIA PINS : 0.8805 +0/-0.0033



RB6872533-2 WRENCH



SECTION B-B

NOTES:

NOTES:

- 1) MATERIAL: O1
- 2) HEAT TREAT: 48-52 Rc
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = $+\/- 0.1"$ / $+\/- 1^\circ$
 X.XX = $+\/- 0.01"$ / $+\/- 0.5^\circ$
 X.XXX = $+\/- 0.005"$ / $+\/- 0.1^\circ$
 X.XXXX = $+\/- 0.0005"$ / $+\/- 0.05^\circ$
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $+\/- 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	ML	REV. B	
MFG. APPR.	JFC	SHEET 3 OF 3	
APPROVED	<i>WSP</i>		
DATE	2019-07-10		
		TOOL PART #	RB6872533
		TITLE	
		WRENCH AND HOLDER INST/REM COMPRESSOR TIE BOLT	
		SCALE	NTS

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